

Date: Tuesday, 11/21/2006 11:29:37 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLAMP KIT
Job Number	: 29563		
Estimate Number	: 12475		
P.O. Number	: <i>N/A</i>	Part Number	: D119756011
This Issue	: 11/21/2006	S.O. No.	: <i>N/A</i>
Prsht Rev.	: <i>NC</i>	Drawing Number	: PRELIMINARY <i>11N-D119-956 Rev C Pg 14</i>
First Issue	: <i>N/A</i>	Project Number	: <i>N/A</i>
Previous Run	: 29534	Drawing Revision	: <i>PREL</i>
	Type : LARGE FAB ASSY	Material	: <i>N/A</i>
Written By	: <i>JA</i> ✓	Due Date	: 11/28/2006
Checked & Approved By	: <i>JA 06 11 21</i>	Qty:	4 Um: Each
Comment	: Est Rev: A New Issue 06-06-27 JLM Est rev B Rev B dwg, picklist 06.07.26 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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(4)

Comment: Photocopy bluefile & type labels per PPPD119-756-011 CHG001

KJ 06 11 21

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Pick Packing Kit

3.0	D26173	Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
 Bushing
 Batch: *B27738* ✓

4.0	D26175	Spacer
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Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)
 Spacer
 Batch: *B27544x4, 27931x10, B29545x2* ✓

5.0	D2732	Rubber Extrusion
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Comment: Qty.: 1.0666 f(s)/Unit Total: 4.2664 f(s)
 RUBBER CUSHION 4 X 3.200" LONG
 Batch: *B26472* ✓

B 06/11/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: CLAMP KIT

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2856400

Abrasion Strip



Comment: Qty.: 0.6382 f(s)/Unit Total: 2.5528 f(s)
Abrasion Strip
Cut into (2) halves to make D2856-200-766 (7.66" LONG)
QTY OF 2
Batch: B28258 ✓

7.0

D30411

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Clamp
Batch: B26217

8.0

D30413

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Clamp
Batch: B24407B

9.0

D30415

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Clamp
Batch: M101440 x3, M29686 x4
computer says no quantities are available

10.0

D30417

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
Clamp
Batch: M101440 x3, B29687 x4
computer says that no quantities are available

11.0

AN417A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)
Bolt
Batch: M101124 ✓

B20611127

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: RD Date: 26/12/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 29563

Part Number: D119756011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

AN420A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bolt

batch: M16895 ✓

13.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Washer

Batch: M102339 ✓

14.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nut

Batch: M19185 ✓

DB 06/11/27

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

PC 6/12/04 (4)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D119-756-011

Location:

PPP Rev: DART

PC 6/12/04 (4)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

DB 06/12/04

Job Completion



u 06/12/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7.0 PARTS LIST

Qty-041	Qty-011	Qty-013	Part Number	Description
X			D119-756-041	HELI-UTILITY-BASKET™
1	X		D119-756-011	CLAMP KIT
		X	D119-756-013	QUICK RELEASE KIT
2			D2022-101	* SPACER
1			D2258-220	* PLACARD
1			D2332-041	* PROP ASSEMBLY
1			D2530	* HANDLE ASSEMBLY
2			D2535	* SPRING
2			D2537	* BUSHING
2	2		D2617-3	BUSHING
4	4		D2617-5	BUSHING
	4		D2732-032	RUBBER CUSHION
	2		D2856-200-766	ABRASION STRIP
2			D2931	* BUMPER
	1		D3041-1	CLAMP
	1		D3041-3	CLAMP
	1		D3041-5	CLAMP
	1		D3041-7	CLAMP
1			D3515-041	* BASKET LID ASSEMBLY
1			D3516-041	* BASKET BASE ASSEMBLY
2			D3516-11	CLEVIS
2			D3517-1	STRUT
2			D3518-041	STRUT ASSEMBLY
2			D3519-1	* PLACARD
2			D3520-1	SPACER
2			AN3-16A	* BOLT
2			AN4-7A	* BOLT
2			AN4-13A	BOLT
6			AN4-15A	BOLT
	2		AN4-17A	BOLT
2	2		AN4-20A	BOLT
1			AN4-22A	* BOLT
1			AN4-24A	* BOLT
2			AN5-10A	BOLT
4			AN5-17A	* BOLT
2			AN960JD416	* WASHER
40	4		AN960JD416	WASHER
2			AN960JD416L	* WASHER
4			AN960JD416L	WASHER
4			AN960JD516	* WASHER
2			AN960JD516L	WASHER
2			AN960JD8	* WASHER
4			AN970-4	* WASHER
		4	BLRS-020	POSITIVE LOCKING QUICK RELEASE PIN
2			MS20600AD4W3	* RIVET
2			MS21042L3	* NUT (OR MS21042-3)
4			MS21042L4	* NUT (OR MS21042-4)
10	4		MS21042L4	NUT (OR MS21042-4)
4			MS21042L5	* NUT (OR MS21042-5)

* indicates that part is pre-assembled on basket for customer

SHOP COPY

RETURN TO

ENGINEERING

CONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 29563

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Revision: C

Date: 06.10.23

